

Date: Thursday, 7/20/2006 1:05:46 PM
User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
Job Number : 27993	
Estimate Number : 10531	
P.O. Number : N/A	Part Number : D2572
This Issue : 7/20/2006 S.O. No. : N/A	Drawing Number : D2572 REV E
Prsht Rev. : NC	Project Number : N/A
First Issue : 7/20/2006 Type : MACHINED PARTS	Drawing Revision : E
Previous Run : 27888	Material : N/A
Written By : <u>[Signature]</u>	Due Date : 8/5/2006
Checked & Approved By : <u>[Signature] 06.07.21</u>	Qty: <u>24</u> 18 Um: Each
Comment : Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572KJ	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6101005	7075-T7351 8.25X5.0X2.5
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
7075-T7351 8.25X5.0X2.5
Make from D6101-005 billet for D2572
Ensure that grain is along 5.00" length
Batch No: B25350

J.G 06/08/14

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No: B27993 Double check by: [Signature]

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove shap edges.

J.G / Er 06/08/17

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2571 & D2572

Er 06/08/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: SP Date: 26/08/08

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 7/20/2006 1:05:46 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 27993

Part Number: D2572

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

3.6 / En 06/08/17

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 06/08/24

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

Q.m 06-08-26

(24)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Q.m 06-08-28

(24)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

Q.m 6/8/28 (24)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 51479

Q.m 6/8/28 (24)

10.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Q.m 06/08/28 (24)

Job Completion



C Low 08/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27993
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	✓	0.440	0.440	0.440		
B	1.745	1.755		1.745	1.747	1.747	1.747		
C	3.495	3.505		3.498	3.498	3.497	3.498		
D	1.745	1.755		1.745	1.747	1.747	1.747		
E	7.990	8.010		7.999	7.999	7.998	7.999		
F	0.490	0.510		0.493	0.496	0.495	0.499		
G	0.257	0.262	DT8683	✓	0.258	0.258	0.258		
H	0.375	0.380	DT8684	✓	0.376	0.376	0.376		
I	0.490	0.510		0.492	0.497	0.498	0.497		
J	1.174	1.184		1.176	1.178	1.178	1.179		
K	0.558	0.578		0.562	0.567	0.567	0.568		
L	1.174	1.184		1.176	1.179	1.180	1.179		
M	1.490	1.500		1.492	1.497	1.496	1.497		
N	2.495	2.505		2.498	2.497	2.497	2.496		
O	3.869	3.879		3.872	3.873	3.871	3.871		
P	0.115	0.135		0.124	0.123	0.122	0.121		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.251	0.251	0.250	0.250		
S	0.115	0.135		0.126	0.124	0.124	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.962	2.961	2.960	2.960		
V	0.230	0.250		0.235	0.234	0.231	0.231		
W	0.115	0.135		0.126	0.127	0.126	0.125		
X	0.307	0.312		0.308	0.309	0.308	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.364	0.361	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.620	0.621	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.243	0.242	0.241	0.244		
AE	1.375	1.395		1.384	1.383	1.383	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.249	0.247	0.247	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	EN / S.G.
Date:	06/08/17

Audited by:	J.L.
Date:	06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27993
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.746	1.747	1.746	1.748		
C	3.495	3.505		3.501	3.500	3.499	3.499		
D	1.745	1.755		1.747	1.747	1.746	1.748		
E	7.990	8.010		8.000	8.001	8.000	8.001		
F	0.490	0.510		0.499	0.497	0.496	0.492		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.501	0.500	0.494	0.494		
J	1.174	1.184		1.180	1.178	1.178	1.177		
K	0.558	0.578		0.569	0.568	0.565	0.562		
L	1.174	1.184		1.180	1.179	1.178	1.177		
M	1.490	1.500		1.501	1.498	1.491	1.491		
N	2.495	2.505		2.499	2.498	2.498	2.495		
O	3.869	3.879		3.873	3.871	3.872	3.873		
P	0.115	0.135		0.121	0.120	0.125	0.123		
Q	0.115	0.135		0.134	0.134	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.257	0.249		
S	0.115	0.135		0.124	0.122	0.125	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.961	2.960	2.960		
V	0.230	0.250		0.241	0.241	0.233	0.232		
W	0.115	0.135		0.134	0.135	0.124	0.127		
X	0.307	0.312		0.310	0.311	0.310	0.309		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.360	0.363	0.365		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.620	0.620	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.248	0.247	0.244	0.243		
AE	1.375	1.395		1.387	1.382	1.383	1.382		
AF	0.115	0.135		0.135	0.134	0.135	0.135		
AG	0.240	0.280		0.261	0.260	0.260	0.260		
AH	0.240	0.260		0.251	0.252	0.248	0.246		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.032	0.030	0.030	0.030		
Accept/Reject									

Measured by:	J.G.	E
Date:	06/08/18	06/08/19

Audited by:	J.L.
Date:	06/08/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27993
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.749	1.748	1.756	1.747		
C	3.495	3.505		3.497	3.500	3.498	3.498		
D	1.745	1.755		1.747	1.748	1.750	1.747		
E	7.990	8.010		8.002	8.000	7.999	8.000		
F	0.490	0.510		0.496	0.496	0.493	0.494		
G	0.257	0.262	DT8683	✓	✓	✓	✓		
H	0.375	0.380	DT8684	✓	✓	✓	✓		
I	0.490	0.510		0.493	0.496	0.497	0.495		
J	1.174	1.184		1.179	1.179	1.175	1.175		
K	0.558	0.578		0.562	0.560	0.560	0.565		
L	1.174	1.184		1.179	1.179	1.175	1.175		
M	1.490	1.500		1.495	1.492	1.494	1.496		
N	2.495	2.505		2.497	2.497	2.498	2.496		
O	3.869	3.879		3.872	3.873	3.872	3.875		
P	0.115	0.135		0.123	0.123	0.123	0.124		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.250	0.249	0.251		
S	0.115	0.135		0.126	0.121	0.126	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.237	0.233	0.233		
W	0.115	0.135		0.177	0.128	0.126	0.124		
X	0.307	0.312		0.311	0.311	0.311	0.316		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.371	0.365	0.366	0.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.670	0.619	0.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.247	0.250	0.246		
AE	1.375	1.395		1.383	1.382	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.245	0.249	0.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	EN
Date:	06/08/21

Audited by:	JML
Date:	06/08/21

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	27993
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

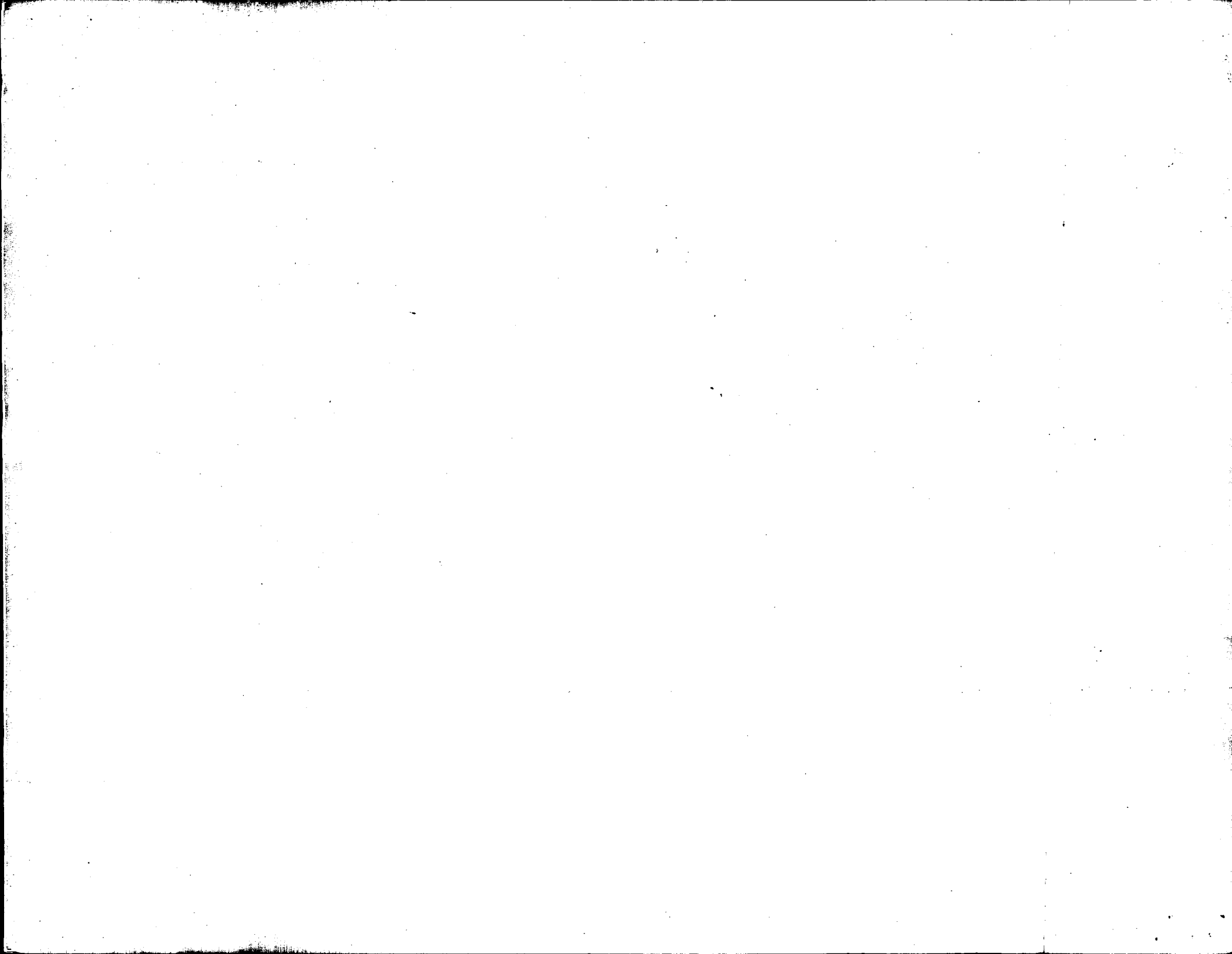
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4 ^{1b}		
A	0.438	0.443	DT8682	/	/	/	/		
B	1.745	1.755		1.745	1.747	1.747	1.747		
C	3.495	3.505		3.500	3.499	3.497	3.496		
D	1.745	1.755		1.745	1.747	1.747	1.747		
E	7.990	8.010		7.999	7.999	7.999	7.999		
F	0.490	0.510		0.494	0.496	0.497	0.498		
G	0.257	0.262	DT8683	/	/	/	/		
H	0.375	0.380	DT8684	/	/	/	/		
I	0.490	0.510		0.493	0.494	0.495	0.494		
J	1.174	1.184		1.177	1.178	1.179	1.179		
K	0.558	0.578		0.562	0.563	0.564	0.563		
L	1.174	1.184		1.177	1.178	1.179	1.180		
M	1.490	1.500		1.496	1.497	1.498	1.497		
N	2.495	2.505		2.499	2.499	2.499	2.497		
O	3.869	3.879		3.873	3.874	3.871	3.872		
P	0.115	0.135		0.124	0.123	0.124	0.125		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.249	0.248	0.249		
S	0.115	0.135		0.125	0.124	0.123	0.124		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.235	0.234	0.235	0.235		
W	0.115	0.135		0.125	0.124	0.125	0.125		
X	0.307	0.312		0.311	0.310	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.370	0.371	0.370	0.371		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.622	0.621	0.622	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.244	0.244	0.244	0.244		
AE	1.375	1.395		1.385	1.383	1.386	1.386		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.266		
AH	0.240	0.260		0.250	0.249	0.251	0.256		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	En / J.G
Date:	06/08/22

Audited by:	J.L
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order: 27993
Description: Saddle, Fwd Inboard	Part Number: D2572
Inspection Dwg: D2572 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682	/	/	/	/		
B	1.745	1.755		1.749	1.749	1.748	1.748		
C	3.495	3.505		3.499	3.498	3.497	3.497		
D	1.745	1.755		1.749	1.749	1.749	1.748		
E	7.990	8.010		8.001	8.001	8.000	8.000		
F	0.490	0.510		0.501	0.500	0.501	0.492		
G	0.257	0.262	DT8683	/	/	/	/		
H	0.375	0.380	DT8684	/	/	/	/		
I	0.490	0.510		0.501	0.499	0.497	0.494		
J	1.174	1.184		1.179	1.179	1.178	1.175		
K	0.558	0.578		0.569	0.568	0.567	0.563		
L	1.174	1.184		1.179	1.178	1.178	1.175		
M	1.490	1.500		1.498	1.497	1.496	1.493		
N	2.495	2.505		2.497	2.495	2.494	2.497		
O	3.869	3.879		3.871	3.870	3.871	3.872		
P	0.115	0.135		0.135	0.125	0.124	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.244	0.241	0.240	0.250		
S	0.115	0.135		0.124	0.125	0.124	0.126		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.961	2.962	2.961	2.960		
V	0.230	0.250		0.236	0.237	0.236	0.238		
W	0.115	0.135		0.124	0.125	0.124	0.126		
X	0.307	0.312		0.310	0.310	0.310	0.311		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.362	0.364	0.365	0.370		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.621	0.622	0.624	0.622		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.251	0.252	0.253	0.244		
AE	1.375	1.395		1.385	1.384	1.382	1.385		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.255	0.254	0.251	0.245		
AI	2.000	2.020		2.001	2.001	2.001			
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by: J.G.	Audited by: J.L.
Date: 06/08/23	Date: 06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order:	27993
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

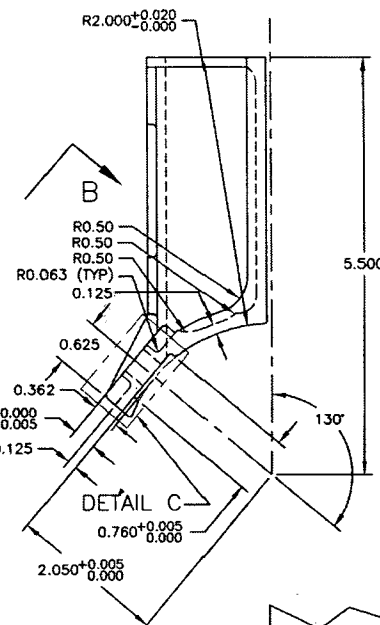
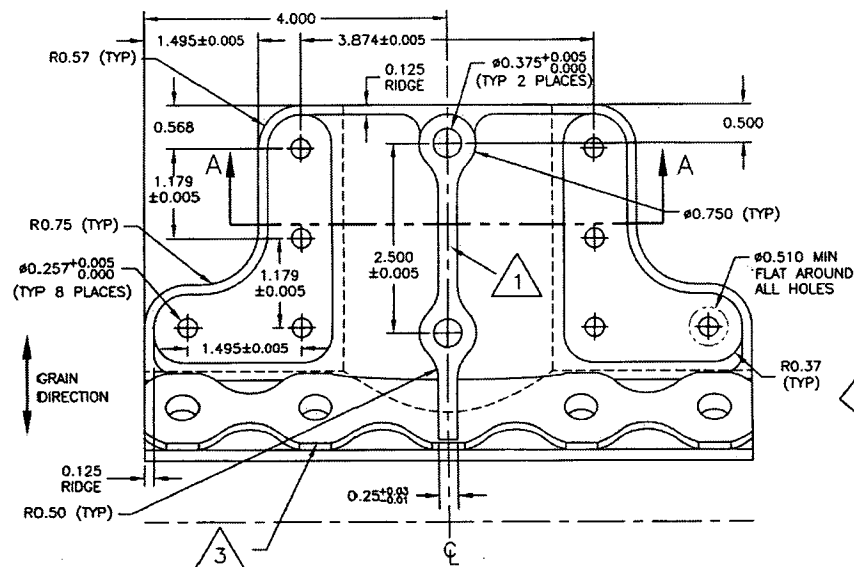
				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4 [#]		
A	0.438	0.443	DT8682	✓	✓	✓	✓		
B	1.745	1.755		1.748	1.746	1.745	1.745		
C	3.495	3.505		3.495	3.499	3.495	3.497		
D	1.745	1.755		1.748	1.746	1.745	1.745		
E	7.990	8.010		8.001	8.002	8.003	8.002		
F	0.490	0.510		0.496	0.495	0.496	0.496		
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684						
I	0.490	0.510		0.496	0.495	0.496	0.498		
J	1.174	1.184		1.175	1.178	1.177	1.175		
K	0.558	0.578		0.563	0.562	0.564	0.563		
L	1.174	1.184		1.175	1.178	1.177	1.175		
M	1.490	1.500		1.492	1.493	1.496	1.494		
N	2.495	2.505		2.497	2.500	2.495	2.498		
O	3.869	3.879		3.871	3.873	3.872	3.870		
P	0.115	0.135		0.121	0.124	0.122	0.123		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.250	0.251	0.250	0.250		
S	0.115	0.135		0.126	0.128	0.128	0.127		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.238	0.243	0.241	0.240		
W	0.115	0.135		0.130	0.128	0.131	0.124		
X	0.307	0.312		0.310	0.311	0.310	0.310		
Y	0.760	0.765		0.765	0.765	0.765	0.765		
Z	0.352	0.372		0.366	0.364	0.360	0.368		
AA	0.470	0.530		0.520	0.520	0.520	0.520		
AB	0.615	0.635		0.623	0.620	0.620	0.621		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.245	0.247	0.248	0.242		
AE	1.375	1.395		1.385	1.396	1.381	1.383		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.248	0.253	0.252	0.249		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		
Accept/Reject									

Measured by:	ER
Date:	06/08/24

Audited by:	JL
Date:	06/08/24

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

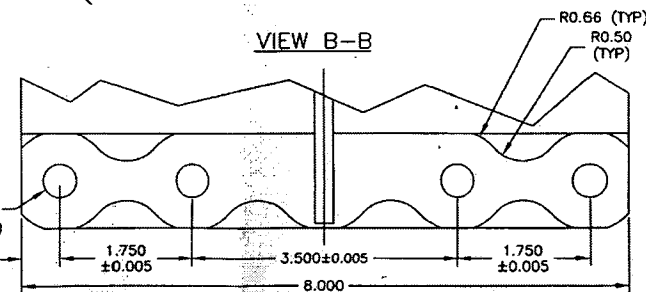
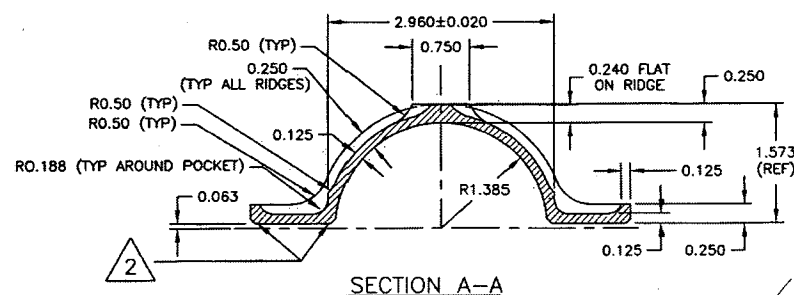
05.12.06



NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D8102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005: 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



DETAIL C
SCALE 2:1

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DART AEROSPACE LTD.

DESIGN	DRAWN BY	 DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA	
DS	PH		
CHECKED 	APPROVED 	DRAWING NO. D2572	REV. E SHEET 1 OF 1
DATE 05.07.13		TITLE INNER FWD SADDLE	SCALE 2:3

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